

PENTAMID AB S L5 H1 natural

Polyamide 66/6 Copolymer

PENTAC Polymer GmbH

Message:

Low viscosity, high heat stabilised polyamide 66+6,easy flow, very easy moulding, impact modified

General Information			
Additive	Impact modifier (5%) heat stabilizer		
Features	Impact modification		
	Low viscosity		
	Good formability		
	Good liquidity		
	Oil resistance		
	Thermal Stability		
Agency Ratings	EC 1907/2006 (REACH)		
Appearance	Natural color		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.11	g/cm³	ISO 1183
Molding Shrinkage			ISO 294-4
Transverse flow	1.4	%	ISO 294-4
Flow	1.4	%	ISO 294-4
Water Absorption			ISO 62
Saturated, 23°C	8.2	%	ISO 62
Equilibrium, 23°C, 50% RH	2.6	%	ISO 62
Viscosity Number	120	cm³/g	ISO 307
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2800	MPa	ISO 527-2/1
Tensile Stress (Yield)	70.0	MPa	ISO 527-2/50
Tensile Strain (Yield)	4.3	%	ISO 527-2/50
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	16	kJ/m²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	No Break		ISO 179/1eU
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, not annealed	180	°C	ISO 75-2/B

1.8 MPa, not annealed	60.0	°C	ISO 75-2/A
Melting Temperature	255	°C	ISO 11357-3
Flammability	Nominal Value		Test Method
Flame Rating			UL 94
1.6 mm	HB		UL 94
3.2 mm	HB		UL 94
Additional Information	Nominal Value		Test Method
ISO Shortname	PA66+PA6, MHR, 12-030		ISO 1874
Injection	Nominal Value	Unit	
Drying Temperature	80	°C	
Drying Time	3.0	hr	
Suggested Max Moisture	0.10 - 0.18	%	
Suggested Max Regrind	20	%	
Rear Temperature	255 - 275	°C	
Middle Temperature	260 - 285	°C	
Front Temperature	265 - 275	°C	
Processing (Melt) Temp	250 - 290	°C	
Mold Temperature	60 - 100	°C	
Injection Pressure	50.0	MPa	
Screw L/D Ratio	18.0:1.0 to 22.0:1.0		
Screw Compression Ratio	2.2:1.0 to 2.8:1.0		

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